

Date: Wednesday, 06/08/2008 9:11:50 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HELI-ACCESS STEP LH (FOLDING)		
Job Number	: 41003						
Estimate Number	: 12567						
P.O. Number	:			Part Number	:	D412630033	
This Issue	: 06/08/2008	S.O. No. :		Drawing Number	:	IIN D412-630	
Prsht Rev.	: NC			Project Number	:	N/A	
First Issue	: / /	Type	LARGE FAB ASSY	Drawing Revision	:	L	
Previous Run	: 40857			Material	:		
Written By	:			Due Date	:	13/08/2008	Qty: 1 Um: Each
Checked & Approved By	:	<i>MF 06-08-06</i>					
Comment	: Est. Rev:A	New Issue	06-11-08 JLM				
	est rev B	ecn 1019, added d2807-041	EC verified by:DD				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			<i>5 oct/08/07</i>
	Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG003		
2.0	D2012107	Clevis	
			<i>AS 08/08/08(XC)</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Clevis Pick: Qty Part Number Description Batch	33585	
	1 D2012-107 Clevis		
3.0	D2803041	Bracket Assembly	
			<i>AS 08/07/08(XC)</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	35826	
	1 D2803-041 Bracket Assembly LH		
4.0	D2804041	Bracket Assembly	
			<i>AS 08/07/08(XC)</i>
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch	40278	
	1 D2804-041 Bracket Assembly LH		

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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2807041 Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Prop

Batch: 35751



AS 08/07/08 (X)

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	34020

7.0 D3562041 Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-041	Step Weldment LH	336492



AS 08/07/08 (X)

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	33578



AS 08/07/08 (X)

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	M101189



AS 08/07/08 (X)

c

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Job Number: 41003		Part Number: D412630033	
Job Number:			
Seq. #:		Machine Or Operation:	
10.0	AN8C16	Bolt	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Pick: Qty Part Number Description Batch M166066 AS 08/07/08 xc	
11.0	AN310C8	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut Pick: Qty Part Number Description Batch M165426 AS 08/07/08 xc	
12.0	MS24665302	Cotter Pin	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Cotter Pin Pick: Qty Part Number Description Batch M167163 AS 08/07/08 xc	
13.0	NAS1515H3	Washer	
		Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s) Washer Pick: Qty Part Number Description Batch M167101 AS 08/07/08 xc	
14.0	NAS1515H5L	WASHER	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) WASHER Pick: Qty Part Number Description Batch M165411 AS 08/07/08 xc	

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Job Number: 41003

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M106540

AS 08/07/08 X

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108618

AS 08/07/08 X

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	<u>M101390</u>

08/07/08 X

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: M104251

E. B. 08/08/08 X

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

C 08/08/08 X

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Job Number: 41003

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	35630

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	34019

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	36521

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	34025

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	107247

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Part Number: D412630033

Job Number:

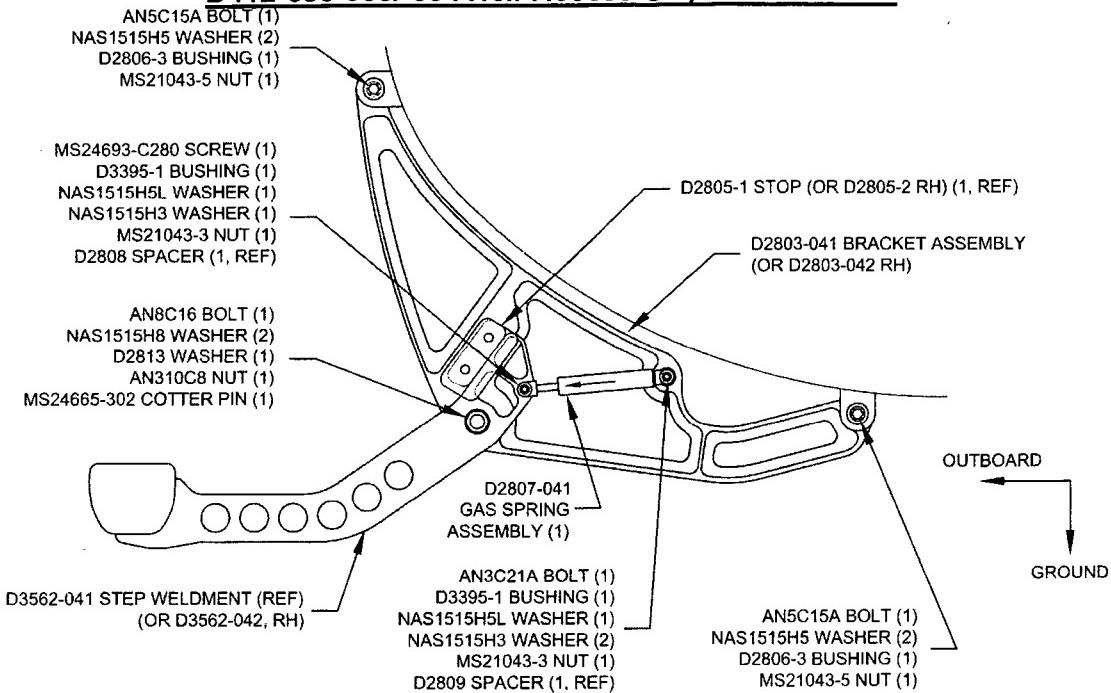


Seq. #:	Machine Or Operation:	Description :	
1	AN4C6A	Bolt	
26.0	AN4C10A	Bolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Bolt		
	Pick: Packing Kit		
	Qty Part Number Description Batch		
	1 AN4C10A Bolt		101189
			AS 08/07/08 (x)
27.0	AN4C15A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Bolt		
	Pick: Packing Kit		
	Qty Part Number Description Batch		
	2 AN4C15A Bolt		M107082
			AS 08/07/08 (x)
28.0	AN44C7A	Eyebolt	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Eyebolt		
	Pick: Packing Kit		
	Qty Part Number Description Batch		
	1 AN44-C7A Eyebolt		M100446
			AS 08/07/08 (x)
29.0	AN5C15A	Bolt	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Bolt		
	Pick: Packing Kit		
	Qty Part Number Description Batch		
	2 AN5C15A Bolt		M105105 ²⁵
			AS 08/07/08 (x)
30.0	NAS1515H4	Washer	
	Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)		
	Washer		
	Pick: Packing Kit		
	Qty Part Number Description Batch		
	7 NAS1515H4 Washer		M106919 X7
			Last of this batch note and AS 08/07/08 (x)

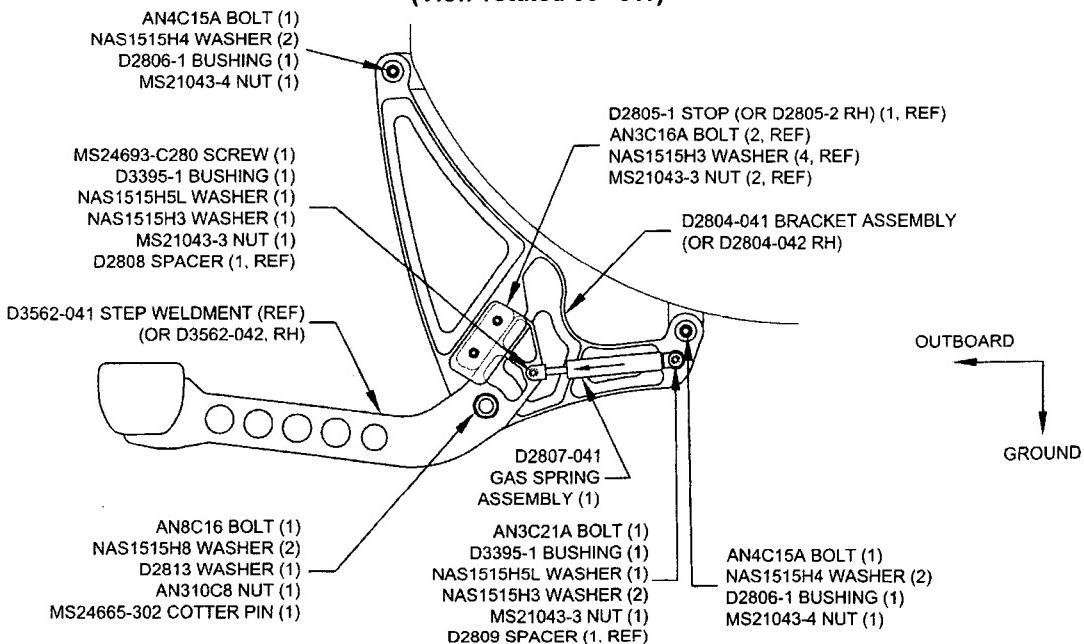
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Job Number:			
Seq. #:	Machine Or Operation:	Description :	
31.0	NAS151H5	Washer	
			
Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s) Washer Pick: Packing Kit		M168334	
Qty Part Number Description Batch		18 08/07/08 (xc)	
7	NAS151H5	Washer	
32.0	MS210434	Nut	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut Pick: Packing Kit			
Qty Part Number Description Batch		18 08/07/08 (xc)	
4	MS21043-4	Nut	M168145
33.0	MS210435	Nut	
			
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Nut Pick: Packing Kit			
Qty Part Number Description Batch		18 08/07/08 (xc)	
3	MS21043-5	Nut	M168583
34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS	
			
Comment: INSPECT 100% KITS FOR COMPLETENESS		18 08/08/08 (xc)	
35.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-033 Location: _____ PPP Rev: _____		18 08/08/08 (xc)	
36.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE		18 08/08/08 (xc)	
Job Completion			
		MF 08-08-07	

D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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